

S. FAB

7449



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RBE350A94-2720-00

Job Sheet 182919



5442

906

Part No: RBE350A94-2720-00

Job Qty: 1 ea

Part Name: Handle, Rotary Adjustment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/6/18

Job Tracking No:

Due Date: 11/7/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE350A94-2720-00 Rev. 2 IPP Rev. A 18.09.05 New issue DP Verify DD

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off         |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|------------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                  |
| 90    | Start up Operation | 1 Ea  |            | 11/7/18  | 0.00      | 0.00    | Start Up Small Fab-4  |           | MLC              |
| 100   | Small Fab          | 1 pcs |            | 11/7/18  | 0.00      | 0.13    | Small Fab-9           |           | MLC DAS          |
| 110   | QC                 | 1 pcs |            | 11/7/18  | 0.00      | 0.00    | QC5                   |           | SEP 13 2018 68   |
| 130   | Packaging          | 1 pcs |            | 11/7/18  | 0.00      | 0.00    | Packaging3-2          |           | 7.10. 9-89       |
| 140   | QC21-FG            | 1 Ea  |            | 11/7/18  | 0.00      | 0.00    | QC21                  |           | SEP 13 2018 9-89 |

Part Op 100 - 1-Assemble as per DWG. \*\*\*Do NOT bond -1 to -11 as per note 2, it's a typo.\*\*\* 2-Bond -15 to -11 and to -1 using Descriptions: Loctite 495.

130 - Identify and Stock

## Job BOM

| Part / Item          | Component Name                 | Quantity    | Operation             | Container |
|----------------------|--------------------------------|-------------|-----------------------|-----------|
| 3855K24              | Knob, Ø1-1/4, 1/4-20 X 1-3/16  | 1 (1 ea)    | 90-Start up Operation | 5109082   |
| 91090A107            | Washer, Ø.266 I.D., Ø.875 O.D. | 1 (1 ea)    | 90-Start up Operation | 5109088   |
| 92735A450            | Clevis Pin, Ø3/8 X 1-1/2"      | 1 (1 ea)    | 90-Start up Operation | 5109017   |
| 97633A170            | External Retaining Ring, 3/8   | 1 (1 ea)    | 90-Start up Operation | 5109087   |
| RBE350A94-2720-00-1  | Handle Weldment                | 1 Ea (1 ea) | 100-Small Fab         | 5109126   |
| RBE350A94-2720-00-11 | Half Clamp Weldment            | 1 Ea (1 ea) | 100-Small Fab         |           |
| RBE350A94-2720-00-15 | Pad                            | 2 Ea (2 ea) | 100-Small Fab         | 5109301   |

## Job Allocations

| Operation             | Component Part       | Required | Inventory | Allocated |
|-----------------------|----------------------|----------|-----------|-----------|
| 90-Start up Operation | 3855K24              | 1        | 0         | 0         |
|                       | 91090A107            | 1        | 0         | 0         |
|                       | 92735A450            | 1        | 0         | 0         |
|                       | 97633A170            | 1        | 0         | 0         |
| 100-Small Fab         | RBE350A94-2720-00-1  | 1        | 0         | 0         |
|                       | RBE350A94-2720-00-11 | 1        | 0         | 0         |
|                       | RBE350A94-2720-00-15 | 2        | 0         | 0         |

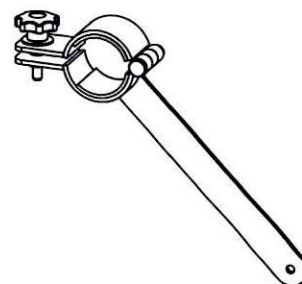
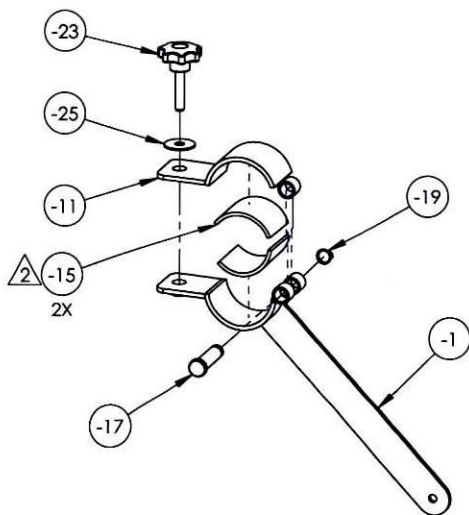
## Part Specifications

Specifications could not be found.

Plex 9/6/18 11:05 AM dart.logan.david

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| REV |         | ECR | DESCRIPTION                                                                                                                                                                                                                   | DATE      | INITIAL | APPROVED |
|-----|---------|-----|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------|---------|----------|
| 1   |         |     | CH'D T/N WAS RBEA94-2720-00 IS RBE350A94-2720-00. -05 ADDED MISSING DIMS FOR R.50. DELETED Ø.236 & MADE HOLE Ø.313 ONLY. -09 ADDED B/O INFO MCMASTER-CARR #90592A016. -11 DELETED -13 ADDED -5 TO WELDMENT. -13 DELETED.      | 5/22/14   | DJN     | RJC      |
| 2   | 15-0063 |     | UPDATED TO NEW DRAFTING STANDARDS. REDESIGNED. CH'D TO STANDARD HARDWARE. -5 REDESIGNED. -7 CH'D DIM WAS Ø.397-.403 IS Ø.374-.375. -9 ADDED DRAWING. -11 REDESIGNED. ADDED -9 TO WELDMENT. -13 REDESIGNED. -15 ADDED DRAWING. | 3/16/2015 | DPD     | JAG      |



# NOTES:

1. REF. EUROCOPTER T/N: 350A94272000.
2. USE ADHESIVE TO ADHERE TO -1 & -11.

| ASSY QTY | ASSY QTY | B/O | Part # | UNIT QTY | Description             | Material   | B/O INFORMATION OR SPECIFICATIONS                         | PG. |
|----------|----------|-----|--------|----------|-------------------------|------------|-----------------------------------------------------------|-----|
|          | X        |     | -1     | 1        | HANDLE WELDMENT         |            |                                                           | 2   |
|          | 1        |     | -3     |          | HANDLE                  | 1018       |                                                           | 3   |
|          | 1        |     | -5     |          | BOTTOM TUBE HALF        | STEEL TUBE | (Ø2-1/8 X .120 WALL)                                      | 4   |
|          | 2        |     | -7     |          | HINGE                   | STEEL TUBE | (Ø1/2 X .065 WALL)                                        | 5   |
|          | 1        |     | -9     |          | CLAMP TAB               | 1018       |                                                           | 6   |
|          | X        |     | -11    | 1        | CLAMP WELDMENT          |            |                                                           | 7   |
|          | 1        |     | -13    |          | TOP TUBE HALF           | STEEL TUBE | (Ø2-1/8 X .120 WALL)                                      | 8   |
|          |          |     | -15    | 2        | PAD                     | RUBBER     | 3/32 THICK. DUROMETER 70 (MCMASTER-CARR #B56BK2) MODIFIED | 1   |
|          |          | B/O | -17    | 1        | CLEVIS PIN              | S.S.       | Ø3/8 X 1-1/2 (MCMASTER-CARR #92735A450)                   | 1   |
|          |          | B/O | -19    | 1        | EXTERNAL RETAINING RING | STEEL      | 3/8 (MCMASTER-CARR #97633A170)                            | 1   |
|          | 1        | B/O | -21    |          | HEX NUT                 | STEEL      | 1/4-20, GRADE 5 (MCMASTER-CARR #95505A601)                | 2   |
|          |          | B/O | -23    | 1        | KNOB                    |            | Ø1-1/4, 1/4-20 X 1-3/16 (MCMASTER-CARR #3855K24)          | 1   |
|          |          | B/O | -25    | 1        | WASHER                  | STEEL      | Ø.266 I.D. . Ø.875 O.D. (MCMASTER-CARR #91090A107)        | 1   |
| ASSY -11 | ASSY -1  |     |        |          |                         |            |                                                           |     |

|                                           |                    |                           |  |
|-------------------------------------------|--------------------|---------------------------|--|
|                                           |                    | TITLE                     |  |
|                                           |                    | HANDLE, ROTARY ADJUSTMENT |  |
| DWG NO.                                   |                    | REV                       |  |
| RBE350A94-2720-00                         |                    | 2                         |  |
| MAT'L                                     | DRAWN BY: WALLRICH |                           |  |
| UNLESS OTHERWISE SPECIFIED                |                    | APPROVED                  |  |
| DIMENSIONS ARE IN INCHES                  |                    | TREAT                     |  |
| .XXX ± .005                               |                    | FINISH                    |  |
| .XX ± .01                                 |                    | SPEC                      |  |
| .X ± .1                                   |                    | USED ON MODEL             |  |
| 1. BREAK ALL SHARP EDGES .016 x 45°       |                    | AS350                     |  |
| 2. DIMENSIONAL LIMITS APPLY AFTER PLATING |                    | SCALE 1:4                 |  |
| DATE 2/20/2015                            |                    | SHEET 1 OF 9              |  |



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**Container No: S109856**



**Part: RBE350A94-2720-00**

**Job No: 182919**

**Serial No/Batch: S109856**

**Revision: 2**

**Inspector:**

**Exp Date:**

**Instructions:**

**Date: 09/13/18**